

Work Order ID 68108

Page 1

Wednesday, April 06, 2011 2:28:23 PM

Item ID: D3488-041

Accept



Setup Start



Revision ID:

Item Name: Blade Fitting Assembly, LH

Stop



Start Date: 4/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11/04/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3488	Rev B

100

0.00



DOOSAN LATHE

Doosan

0.00

Doosan Lathe

Memo

1-Turn as per Dwg DSK 101 & Folio FA625□2-Deburr

nl 11.4.26

12 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

0.00

Quality Control

nl 11.4.26

12 0

120

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS I

0.00

HAAS CNC vertical machine #1

Memo

1-Machine as per Folio FA625 & Dwg D3488□2-Deburr

nl 11.4.26

12 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/05/03

0.00

12 0

QC

Quality Control

140



QC8- Inspect parts - second check

0.00

B.4 11/05/04

0.00

12 0

QC

Quality Control

150



Chemical Conversion Coat per QSI005 4.1

0.00

0.00

12 BL 11-5-12.

HandFinish

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68108

Wednesday, April 06, 2011 2:28:23 PM



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Item ID: D3488-041

Accept



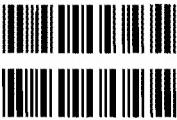
Setup Start



Revision ID:

Item Name: Blade Fitting Assembly, LH

Stop



Start Date: 4/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
Description

160



Powdercoat

Powder Coating

N116964

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

OVEN TEMPERATURE:

M^{emo}

10:30

11:00

12X Ø M/L 11/06/16

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

M^{emo}

0.00

12 Bl 11-05-16

180



HandFinish

Hand Finishing

HandFinishing

0.00

M^{emo}

0.00

Install Inserts as per Dwg D3488

12 d M u/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68108

Wednesday, April 06, 2011 2:28:23 PM

Page 4

Item ID: D3488-041

Accept



Setup

Start



Revision ID:

Item Name: Blade Fitting Assembly, LH

Stop



Start Date: 4/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S 110517

(CR)

WT

200



Packaging

Packaging

Identify as per dwg & Stock Location: FP-8

0.00

0.00

12 d M 110517

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/5/18 (2)

11/11/18 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, April 06, 2011 2:28:30 PM

Work Order ID: 68108



Parent Item: D3488-041



Parent Item Name: Blade Fitting Assembly, LH

Start Date: 4/6/2011

Required Date: 4/13/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:
IPP Rev:A New Issue 06-02-28 JLM
IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALST1032-225		Purchased		No			Each	700.0000		48		11/05/17	

INSERT

Location	Loc Qty	Loc Code
ST282	700	AL110768
100896	100	
111529	300	
111581	300	

D6103-003	Manufactured	No		Each	6.0000	12	11.5.18
Round Billet, Aluminum							

Location	Loc Qty	Loc Code
MAT043	6	
55430	3	
65955	3	

18173 (x12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68108
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.150	/		Rp. 02	
Ø2.780	+/-0.005	2.780	/		All.	
Ø3.125	+/-0.010	3.125	/			
Ø3.346	+/-0.010	3.347	/			
0.125 x 45°	+/-0.010 x +/-0.1°	.125 x 45°	/			
8.000	+0.030/-0.000	8.015	/			
9.250	+/-0.010	9.250	/			
0.188	+/-0.010	.188	/			
R0.032	+/-0.010	R.032	/			
R0.062	+/-0.010	R.062	/			
Ø0.297	+0.005/-0.001	.298	/			
Ø0.430	+/-0.010	.430	/			
0.100	+/-0.010	.100	/			
0.125	+/-0.010	.125	/			
2.620	+/-0.010	2.620	/			
3.500	+/-0.010	3.500	/			
1.005	+/-0.010	1.005	/			
Ø0.484	+0.005/-0.001	.484	/			
1.180	+/-0.010	1.180	/			
3.150	+/-0.010	3.150	/			
3.070	+/-0.010	3.070	/			
R0.063	+/-0.010	R.063	/			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	6810 d
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2	Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	509	/		(brn) SJ 3	
0.750	+/-0.010	754	/		H-G	
1.500	+/-0.010	1500	/		"	
11.18	+/-0.030	11.183	/		H-G	
R0.062	+/-0.010	062	/		R-G	
0.125	+/-0.010	125	/		"	
0.590	+/-0.010	590	/		H-G	
0.793	+/-0.010	796	/		H-G	
1.351	+/-0.010	1347	/			
1.317	+/-0.010	1323	/		"	
1.802	+/-0.010	1.806	/		H-G	

Measured by:	SL	Audited by:	B.A.	Prototype Approval:	N/A
Date:	11/05/03	Date:	11/05/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	JL

W/O:		WORK ORDER CHANGES					
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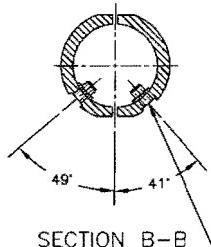
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

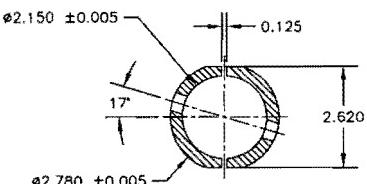
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AN ENDMENT
WITHOUT NOTICE
WORK ORDER
NO. G8108



SECTION B-B
φ0.297
C'BORE φ0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225)
OR ALS7-1032-225 OR AKS7-1032-225
INSERTS AFTER FINISH
(4 PLACES)

4



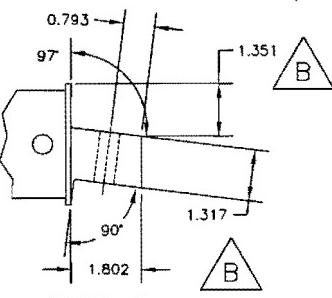
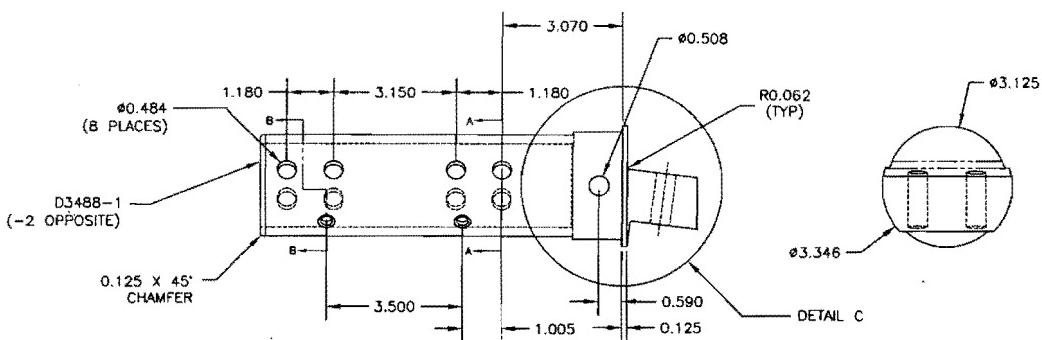
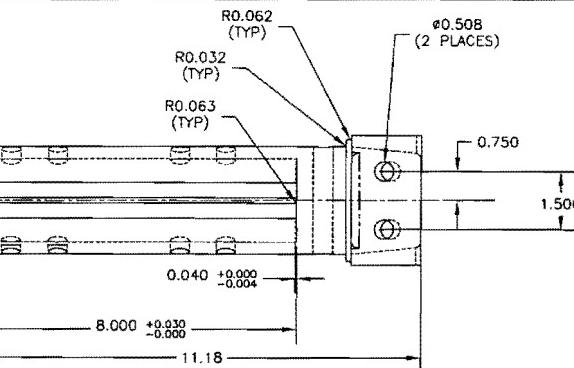
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042	D3488-041	BLADE FITTING ASSEMBLY (LH)
X	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1	1	D3488-1	BLADE FITTING (LH)
1	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- 1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) INSTALL INSERTS AFTER POWDER COAT
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
PER OS
ECN #737

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DRAWING NO.	D3488	REV. B
DATE	06.03.15	SHEET 1 OF 1
TITLE	BLADE FITTING	SCALE 1:3

W/O:		WORK ORDER CHANGES					
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